

Del 500

Work Order ID 70526

Friday, June 10, 2011 11:42:29 AM



Page 1

Item ID: D3443-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Pin

Start Date: 6/10/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: *✓*

Date: *110610* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3443	Rev C								
100		0.00							
	Hardinge CNC LATHE SMALL								
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	I-TURN AS PER FOLIO FA698 & DWG D3443, <input type="checkbox"/> FOLIO REV: <i>C</i> <input type="checkbox"/> DWG REV: <i>C</i> <input type="checkbox"/> 2-DEBURR AS REQUIRED		<i>51</i>	<i>1116122</i>					
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	Memo	0.00							
QC									
Quality Control									
120	QC8- Inspect parts - second check	0.00							
	Memo	0.00							
QC									
Quality Control									

6 6

6 6

21 1116122

Re 11. 6. 22

6 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70526

Friday, June 10, 2011 11:42:30 AM



Page 2

Item ID: D3443-9

Accept



Setup Start



Revision ID:

Item Name: Pin

Stop



Start Date: 6/10/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Packaging

Packaging

Operation
DescriptionIdentify as per dwg & Stock Location: 54Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

6

11/02/22

S

0.00

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/02/23

ME

11-06-23

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Friday, June 10, 2011 11:42:35 AM

Work Order ID: 70526



Parent Item: D3443-9



Parent Item Name: Pin

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP rev A 05.12.19 new issue ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR0.500 		Purchased		No		110	f	79.9750	0.0875	0.552632		SD 456/22	

Delrin Round Bar .50"

Location	Loc Qty	Loc Code
MAT055	79.975	
109571	29.975	
18355	50	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	70526
Description: Pil	Part Number:	A3443-9
Inspection Dwg: A3443 Rev: C		Page 1 of 1

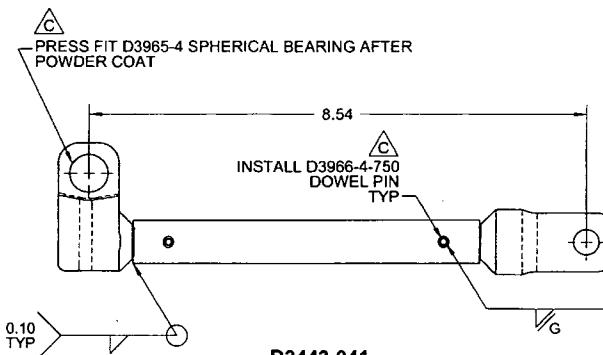
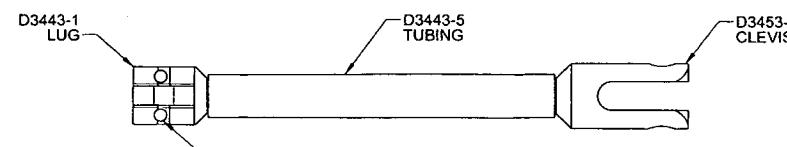
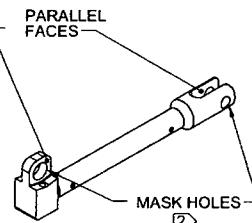
FIRST ARTICLE INSPECTION CHECKLIST

Measured by: <u>SJ</u>	Audited by: <u>DS</u>	Preliminary Approval:
Date: <u>11/16/22</u>	Date: <u>11. 6. 22</u>	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

ITEM	QTY	P/N	DESCRIPTION
1	X	D3443-041	STRUT WELDMENT ASSEMBLY
2	1	D3443-1	LUG
3	1	D3443-5	TUBING
4	1	D3453-1	CLEVIS
5	1	D3965-4	BEARING, SPHERICAL
6	2	D3966-4-750	PIN, DOWEL



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.33 lbs
- 8) WELD PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70524
11/06/10

RELEASED
09/08/2010

C	DRAWING UPDATED TO CURRENT STANDARDS. REVISED NOTE #2 (ZN A8-1, A8-2): 0.820 WAS 0.720 & 1.43 WAS 1.53 (ZN C2-3): 0.551 WAS 0.451 (ZN C1-3); R0 2.19 WAS R0.050 (ZN C4-3); D3965-4 WAS SPAENAUER P/N (ZN C6-1, B5-2); D3966-4-750 WAS McMaster-Carr P/N (ZN B5-1); REF PAR 09-018	RF	09.06.25
B	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & 0.0125 WAS #30	RF	05.12.05
A	NEW ISSUE	RF	05.09.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>Y</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>Y</i>	D3443	SHEET 1 OF 4
APPROVED	<i>Y</i>	TITLE	SCALE
DE APPR.	<i>Y</i>	STRUT WELDMENT ASSEMBLY	NTS
DATE	09.06.25	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

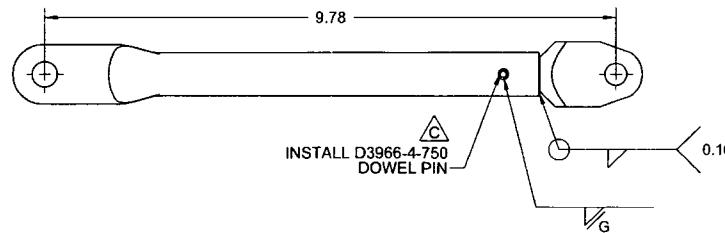
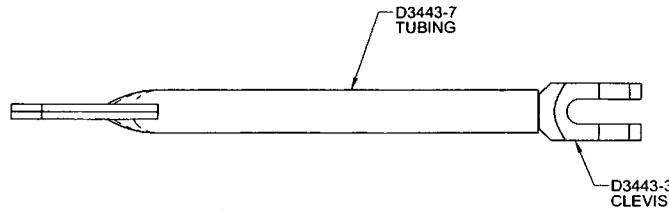
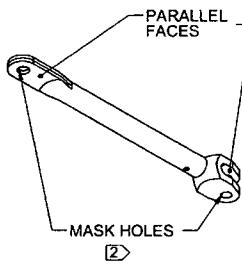
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3443-043	STRUT WELDMENT ASSEMBLY
2	1	D3443-3	CLEVIS
3	1	D3443-7	TUBING
4	1	D3966-4-750	PIN



D3443-043

RELEASED
09/06/25 M

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.97 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	up	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	REV. C
APPROVED	<i>[Signature]</i>	D3443 SHEET 2 OF 4
DE APPR.	<i>[Signature]</i>	TITLE
DATE	09.06.25	SCALE
		STRUT WELDMENT ASSEMBLY

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8 7 6 5 4 3 2 1

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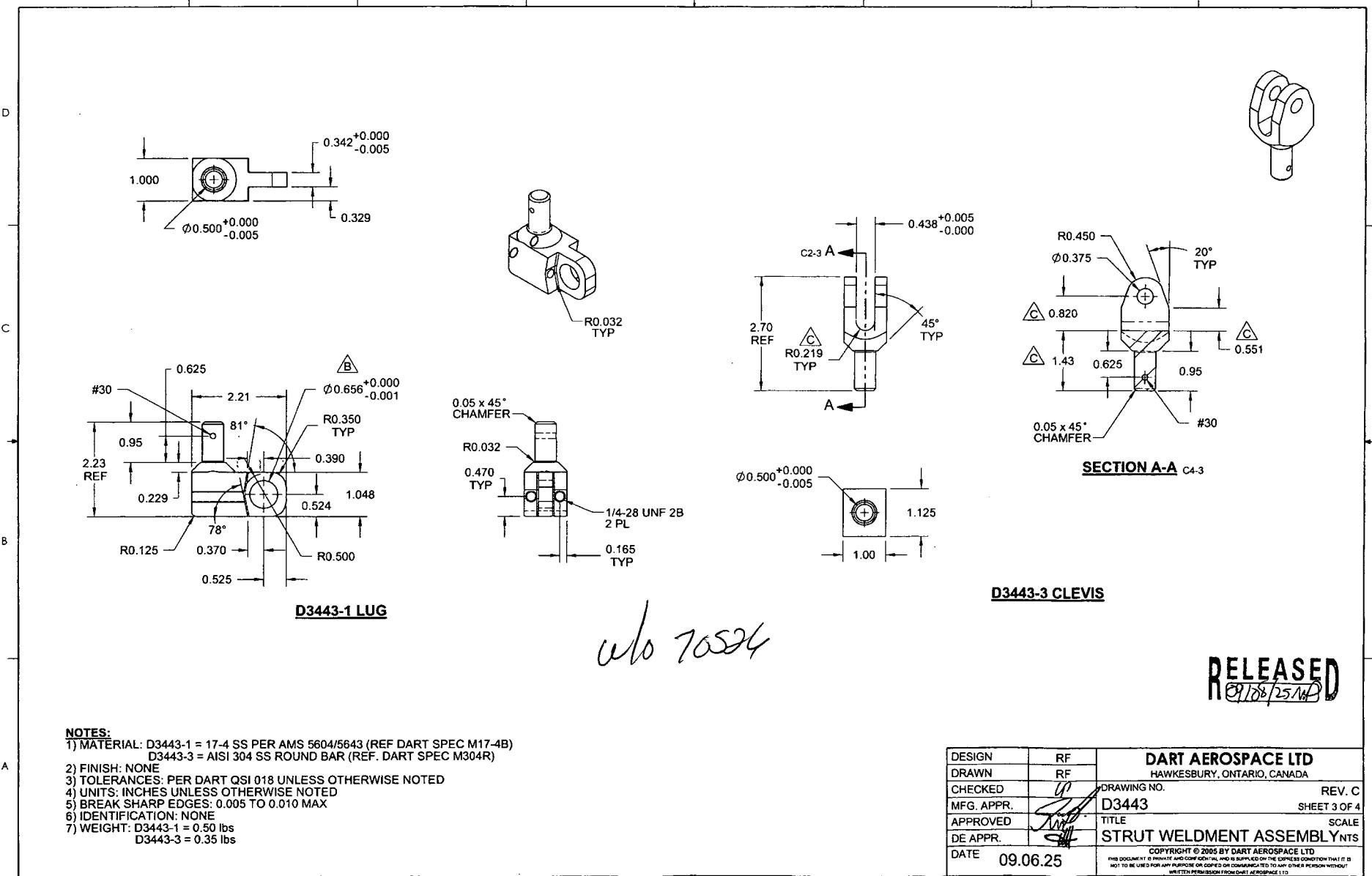
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8 1 7 6 5 4 3 2 1



DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	Y	DRAWING NO. REV. C
MFG. APPR.		D3443 SHEET 3 OF 4
APPROVED		TITLE
DE APPR.		SCALE
DATE	09.06.25	STRUT WELDMENT ASSEMBLY NTS

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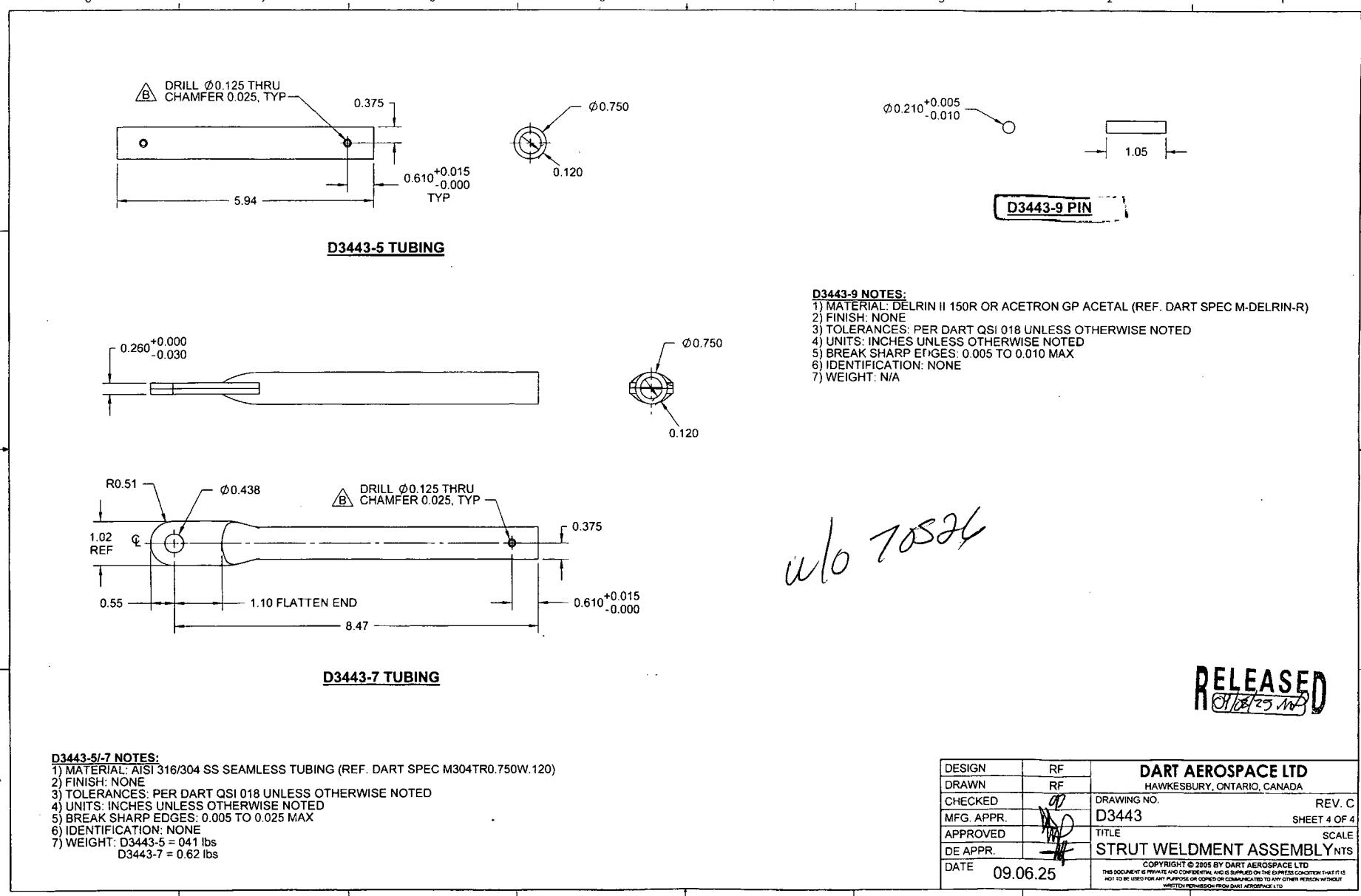
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